



0217

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

5138491

RBW6205G00632-3G
Job Sheet 183987-A

**Part No:** RBW6205G00632-3G**Job Qty:** 1 ea**Part Name:** Sling, Main Rotor Blade Lift**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 12/18/18**Job Tracking No:****Due Date:** 12/17/18**Created By:** Linda Lacelle**Type:** Stock**Description:****Note:** DWG RBW6205G00632-3G Rev 6 IPP Rev A 18.01.11 New issue DP Verify DD**Ship Via:**

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	QC	1 pcs		12/17/18	0.00	0.00	QC6		
121	Small Fab	1 pcs		12/17/18	0.00	2.00	Small Fab-5		MLL
122	QC	1 pcs		12/17/18	0.00	0.00	QC5		DAS
130	Packaging	1 pcs		12/17/18	0.00	0.00	Packaging3		28
140	QC21-FG	1 Ea		12/17/18	0.00	0.00	QC21		DAS 21 FEB 25 2019

Part Op 121 - PERFORM FIRST ARTICLE WEIGHT TEST 1. AFTER INSPECTION, PLACE 300 LBS. IN M/R BLADE LIFTING
Descriptions: TOOL. LIFT M/R BLADE LIFTING TOOL USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES,
CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION. 2- REMOVE WEIGHT AND RE-INSPECT
TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS. Fill out inspection sheet. (sheet 47). 3-
Engrave RB41011 placard. 4-Transfer drill placard as per DWG. 5-Using #2 drive screws install placard 6-Apply sticker as
per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90081A074	0.125 X 0.500 #2 Drive Screw	4 Ea (4 ea)	121-Small Fab	3047391
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	121-Small Fab	3021040
RBW6205G00632-3G-77	Sticker	1 Ea (1 ea)	121-Small Fab	3142773

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
121-Small Fab	90081A074	4	159	0
	RB41011	1	529	0
	RBW6205G00632-3G-77	1	2	0

Part Specifications

Specifications could not be found.

JART
AEROSPACE

Jart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 532-5200
Email: sales@jarto.com
www.jarto.com

Container No: S138491



Part: FBW6205G00632-3G

Job No: 183987-A

Serial No/Batch: S137938

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 02/20/19

340
65



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G00632-3G
Job Sheet 183987



split
(2)

Part No: RBW6205G00632-3G

Job Qty: 3 ea

Part Name: Sling, Main Rotor Blade Lift



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 12/17/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G00632-3G Rev 6 IPP Rev A 18.01.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		12/17/18	0.00	0.00	Purchasing		<i>DEC 17 2018</i>
110	Packaging	3 pcs		12/17/18	0.00	0.00	Packaging2		<i>DEC 17 2018</i>
120	QC	3 pcs		12/17/18	0.00	0.00	QC6		
121	Small Fab	3 pcs		12/17/18	0.00	6.00	Small Fab-5		
122	QC	3 pcs		12/17/18	0.00	0.00	QC5		
130	Packaging	3 pcs		12/17/18	0.00	0.00	Packaging3		
140	QC21-FG	3 Ea		12/17/18	0.00	0.00	QC21		

Part Op 100 - Issue P/O: *041199* MANUFACTURE RBW6205G00632-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required
121 - PERFORM FIRST ARTICLE WEIGHT TEST 1. AFTER INSPECTION, PLACE 300 LBS. IN M/R BLADE LIFTING TOOL. LIFT M/R BLADE LIFTING TOOL USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION. 2- REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS. Fill out inspection sheet. (sheet 47). 3- Engrave RB41011 placard. 4-Transfer drill placard as per DWG. 5-Using #2 drive screws install placard 6-Applly sticker as per DWG.

oct 01 x 3 *PL*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G00632-3GP	Sling, Main Rotor Blade Lift	3 pcs (1 ea)	100-Purchasing	<i>5137937</i>
90081A074	0.125 X 0.500 Drive Screw	12 Ea (4 ea)	121-Small Fab	<i>5047591</i>
RB41011	Dart Tooling Placard, Aluminum	3 Ea (1 ea)	121-Small Fab	<i>5021040</i>
RBW6205G00632-3G-77	Sticker	3 Ea (1 ea)	121-Small Fab	

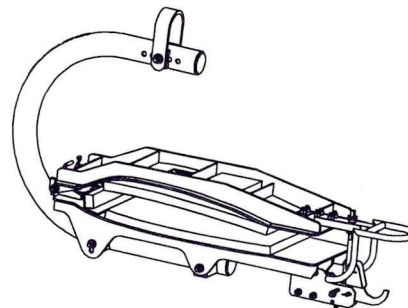
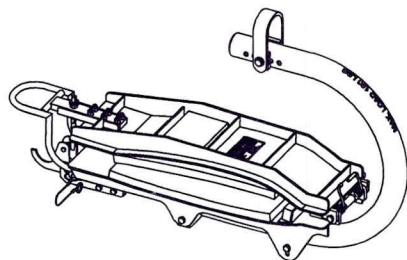
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G00632-3GP	3	0	0
121-Small Fab	90081A074	12	76	0
	RB41011	3	771	0
	RBW6205G00632-3G-77	3	4	0

Part Specifications
Specifications could not be found.

Plex 10/1/18 11:36 AM dart.Lussier.Patrick

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ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	
					X		-1	1	LOWER JAW WELDMENT			4								B/O	-81	2	BOLT	STEEL	5/16-24 X 7 (MCMaster-CARR #91257A453)	3
					2		-3		LOWER JAW SIDE PLATE	6061		5								B/O	-83	1	BOLT	STEEL	5/16-24 X 6-1/2 (MCMaster-CARR #91257A451)	3
					1		-5		LOWER JAW FACE PLATE	5052		6								B/O	-85	3	LOCK NUT	STEEL	5/16-24 (MCMaster-CARR #97135A225)	3
					1		-7		LOWER JAW LATCH PLATE	6061		7								B/O	-87	3	WASHER	STEEL	05/16 (MCMaster-CARR #90126A030)	3
					1		-9		LOWER JAW ANGLE	5052		8								B/O	-89	5	BOLT	STEEL	1/4-28 X 1-1/4 (MCMaster-CARR #91286A138)	3
				2	2		-11		HINGE PLATE	6061		9								B/O	-91	6	MACHINE SCREW	S.S.	1/4-28 X 1-1/4 (MCMaster-CARR #91771A563)	3
				4	5		-13		LOWER JAW BRACE	6061		10								B/O	-93	5	LOCK NUT	STEEL	1/4-28 (MCMaster-CARR #97135A215)	3
				X			-15	1	UPPER JAW WELDMENT			11								B/O	-95	16	WASHER	STEEL	1/4 (MCMaster-CARR #95229A420)	3
				2			-17		UPPER JAW SIDE PLATE	6061		12								B/O	-97	2	SPACER	AL	01/2 X 1/8 (MCMaster-CARR #92510A760)	3
				1			-19		UPPER JAW PLATE	5052		13								B/O	-99	1	BOLT	STEEL	3/8-24 X 3-3/4 (MCMaster-CARR #91257A464)	3
				1			-21		ANGLE BRACE	6063		14								B/O	-101	1	LOCK NUT	STEEL	3/8-24 (MCMaster-CARR #97135A235)	3
				1			-23		ANGLE BRACE 2	6063		15								B/O	-103	2	WASHER	STEEL	3/8 (MCMaster-CARR #98023A031)	3
				2			-25		UPPER JAW BRACE, SHORT	6061		16								B/O	-105	2	THUMB NUT	S.S.	3/8-16 (MCMaster-CARR #95150A190)	3
				X			-27	1	HANDLE WELDMENT			17								B/O	-107	1	CLEVIS PIN	S.S.	01/4 X 1 (MCMaster-CARR #92390A159)	3
				1			-29		HANDLE	6063		18								B/O	-109	1	CLEVIS PIN	S.S.	01/4 X 1-1/8 (MCMaster-CARR #92390A160)	3
				2			-31		HANDLE ARM	6063		19								B/O	-111	1	SPACER	STEEL	01/2 OD X 01/4 ID X 3/4 (MCMaster-CARR #92415A867)	3
				1			-33		HANDLE BRACE	6063		20									-113	1	LATCH SPRING	302 S.S.	0.25 OD X 0.026 X 2 (MCMaster-CARR #9665K85) MODIFIED	45
				1			-35		LATCH BLOCK	6061		21								B/O	-115	1	BALL LOCK PIN	S.S.	01/4 X 3/4 (MCMaster-CARR #92384A033)	3
				X			-37	1	HOOK WELDMENT			22								B/O	-117	2	COTTER PIN	STEEL	01/16 X 3/4 (MCMaster-CARR #98338A105)	3
				1			-39		ROD	304 S.S.		23								B/O	-123	4	#2 DRIVE SCREW	COATED STEEL	1/8 (MCMaster-CARR #90081A074)	3
				1			-41		HOOK	304 S.S.		24								B/O	-125	1	LANYARD	STEEL	01/16 X 6 (CARR LANE #CL2C)	3
				X			-43	1	LATCH WELDMENT			25								B/O	-127	2	FERRULE	ALUMINUM	01/16 X 3/8 (MCMaster-CARR #3896T31)	3
				1			-45		LATCH CATCH	5052		26								B/O	-129	1	SPLIT RING	STEEL	07/8 (MCMaster-CARR #90177A217)	3
				1			-47		LATCH HOOK	6061		27								B/O	-131	6	THIN LOCK NUT	STEEL	1/4-28 (SPENCER AIRCRAFT #MS210R3-N4)	3
				X			-49	2	LATCH BRACKET	6061		28								B/O	-133	1	FOAM PAD	Y20 BLACK	1 X 3-3/4 X 5 IR SPECIALTIES	46
				1			-50	1	LIFT ARM WELDMENT			29										1	DART PLACARD	ALUMINUM	#9841011	3
				1			-51		LIFT ARM	6061		30	ASSY -69	ASSY -50	ASSY -43	ASSY -37	ASSY -27	ASSY -15	ASSY -1							
				2			-52		LIFT ARM END CAP	6061		31														
							-53	1	CLEVIS	A-36 P & Q		32														
							-55	2	SPACER BLOCK	6061		33														
							-57	4	HANDLE BLOCK	6061		34														
							-59	1	HINGE SPACER	6061		35														
							-61	1	SHORT HINGE SPACER	6061		36														
						B/O	-63	2	FOAM	T-20	3/4 X 8 X 15-1/8 (CASE SOLUTIONS)	37														
						B/O	-65	1	FOAM, ANGLE BLOCK	T-20	3/4 X 1-1/8 X 8 (CASE SOLUTIONS)	38														
						B/O	-67	2	FOAM BACKING	NEOPRENE	1/8 X 8 X 15-1/4 GASKET SPECIALTY	39														
				X			-69	2	SPRING ASSEMBLY			40														
				1			-71		SPRING	S.S.	DENDOFF	41														
				1			-73		TUBE, LONG	NYLON	01/4 OD .17 ID X1-3/8 (MCMaster-CARR #5548K64)	42														
				1			-75		TUBE, LONG	NYLON	01/4 OD .17 ID X 1/2 (MCMaster-CARR #5548K64)	43														
						B/O	-77	1	STICKER	VINYL, BLACK	TEXT: ARIAL HT; 1/2 SIGNS NOW	44														

DART AEROSPACE	
TITLE TOOL, M/R BLADE LIFTING	
DWG NO. RBW6205G00632-3G	REV 6
MATERIAL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES ± 125	
CHECKED BY: GILBERT	1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: CLOUGH	USED ON MODEL
APPROVED: LINDSAV	AW139
SCALE 1:6	DATE 2/21/2013
SHEET 1 OF 47	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041199**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041199

PO Date: 10/1/18

Due Date: 12/17/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183987	RBW6205G00632-3GP			Sling, Main Rotor Blade Lift As per Dwg RBW6205G00632-3G Rev. 6	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$6,548.85/pcs	\$19,646.55
<i>3X DEC 17 2018</i> <i>ORDER 7086</i> <i>ORDER 7393</i> <i>JAN 08 2019</i> <i>16 DEC 20</i>													
Line Item Note SIOP													
2	183988	RBW6205G11532-3GP			Swashplate Support Stand As Per Dwg RBW6205G11532-3G	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$8,811.00/pcs	\$17,622.00
<i>REV 5</i> <i>ORDER 11506</i> <i>JAN 31 2019</i>													
Line Item Note SIOP													
3	183990	RBW7105G00231-3GP			Engine Lifting Tool As Per Dwg RBW7105G00231-3G Rev. 10	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$2,879.00/pcs	\$5,758.00
<i>1</i>													
Line Item Note SIOP													
4	183991	RBW7105G00131-3GP			Engine Transport Stand As Per Dwg RBW7105G00131-3G Rev. 6	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$4,717.00/pcs	\$9,434.00
Line Item Note SIOP													
												Grand Total:	\$52,460.55



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041199

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 10/1/18 11:58 AM dart.Lussier.Patrick

**METAL TECHNOLOGY INC.****www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956**

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Att. Patrick Lussier

Shipment No: 24400
Shipment Date: 17-Dec-2018
Ship Via: our truck
Order Number: 3064
Order Date: 10/01/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041199 R3 ✓
Terms: Net 60 Days

----- Quantity -----								Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
1	3	3 ✓	0	0	EA	DART-RBW6205G00632-3GP Sling, Main Rotor Blade Lift, drawing # RBW6205G00632-3 Rev.6	6	3064-02

DAG
38
9-88

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Att. Patrick Lussier



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

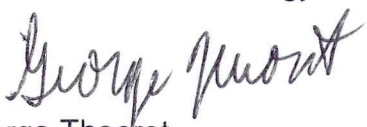
Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
3	DART-RBW6205G00632- 3GP	Sling, Main Rotor Blade Lift, drawing # RBW6205G00632-3 Rev.6	6	41199 R3 ✓

MATERIAL: supplied by METEC

QAS
38
-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Theoret

Vankleek Hill, December 17, 2018

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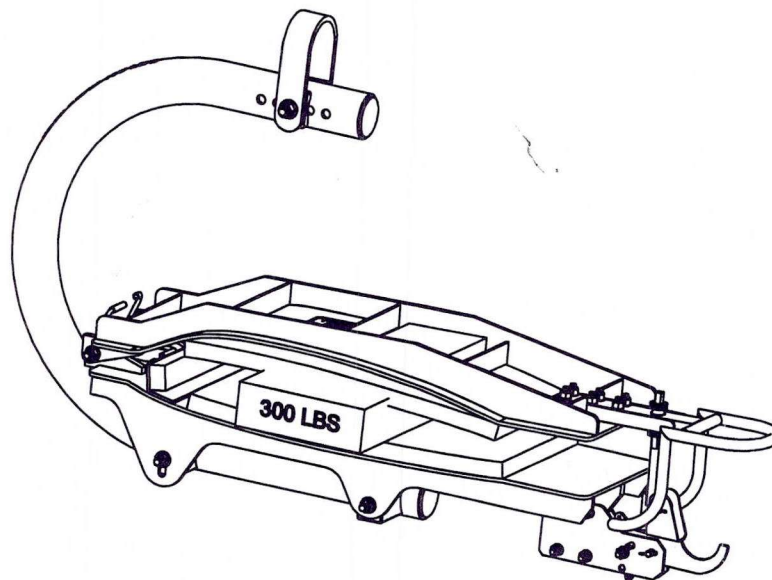
REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				

FIRST ARTICLE WEIGHT TEST

INSPECTION & TESTING PROCEDURES FOR THE RBW6205G00632-3G, M/R BLADE LIFTING TOOL. THIS ASSEMBLY IS DESIGNED TO LIFT A MAIN ROTOR. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE 300 LBS. IN M/R BLADE LIFTING TOOL. LIFT M/R BLADE LIFTING TOOL USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
3. REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.



INSPECTOR: Guy Morgan

TESTER: [Signature]

S.N.: S137933 PD

DATE: 5 Dec 2016

DART
AEROSPACE

190 S. Danebo Ave., Eugene, OR. 97402
1-800-556-4166
e-mail: sales@dartaero.com
dartaerospace.com

TITLE TOOL, M/R BLADE LIFTING			
DWG NO. RBW6205G00632-3G	REV 6	CUSTOMER 1 OF 1	
SCALE 1:8	DATE 2/21/2013	SHEET 47 OF 47	

WO # 3064